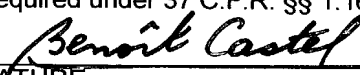


JG18 Rec'd PTO 04 MAR 2002

TRANSMITTAL LETTER OF THE UNITED STATES DESIGNATED/ELECTED OFFICE (DO/EO/US) CONCERNING A FILING UNDER 35 U.S.C. 371		Attorney Docket No. 2004-1001 U.S. Application f 10/070250
INTERNATIONAL APPLN. NO. PCT/NL00/00618	INTERNATIONAL FILING DATE 04 SEPTEMBER 2000 (04.09.00)	PRIORITY DATE CLAIMED 03 SEPTEMBER 1999 (03.09.99)
TITLE OF INVENTION: METHOD FOR PROVIDING TEXTURES ON PRODUCTS		
APPLICANT(S) FOR DE/EO/US: ADRIAAN HENDRIK VAN KRIEKEN AND RENZO BOUWE VAN DER PLAS		
Applicant herewith submits to the United States Designated Elected Office (DO/EO/US) the following items and other information:		
<ol style="list-style-type: none"> 1. <input checked="" type="checkbox"/> This is a FIRST submission of items concerning a filing under 35 U.S.C. 371. 2. <input type="checkbox"/> This is a SECOND or SUBSEQUENT submission of items concerning a filing under 35 U.S.C. 371. 3. <input checked="" type="checkbox"/> This is an express request to begin national examination procedures (35 U.S.C. 371(f)). The submission must include items (5), (6), (9) and (21) indicated below. 4. <input checked="" type="checkbox"/> The US has been elected by the expiration of 19 months from the priority date (Article 31). 5. <input checked="" type="checkbox"/> A copy of the International Application as filed (35 U.S.C. 371 (c)(2)) <ol style="list-style-type: none"> a. <input checked="" type="checkbox"/> is attached hereto (required only if not communicated by the International Bureau) b. <input type="checkbox"/> has been communicated by the International Bureau. See attached PCT/IB/308. c. <input type="checkbox"/> is not required, as the application was filed in the United States Receiving Office (RO/US). 6. <input type="checkbox"/> An English language translation of the International Application as filed (35 U.S.C. 371 (c)(2)) <ol style="list-style-type: none"> a. <input type="checkbox"/> is attached hereto. b. <input type="checkbox"/> has been previously submitted under 35 U.S.C. 154(d)(4). 7. <input type="checkbox"/> Amendments to the claims of the International Application under PCT Article 19 (35 U.S.C. 371 (c)(3)) <ol style="list-style-type: none"> a. <input type="checkbox"/> are attached hereto (required only if not communicated by the International Bureau). b. <input type="checkbox"/> have been communicated by the International Bureau. c. <input type="checkbox"/> have not been made, however, the time limit for making such amendments has NOT expired. d. <input type="checkbox"/> have not been made and will not be made. 8. <input type="checkbox"/> An English language translation of the amendments to the claims under PCT Article 19 (35 U.S.C. 371 (c)(3)). 9. <input type="checkbox"/> An oath or declaration of the inventor(s) (35 U.S.C. 371(c)(4)). 10. <input type="checkbox"/> An English language translation of the annexes of the International Preliminary Examination Report under PCT Article 36 (35 U.S.C. 371(c)(5)). 		
Items 11 to 20 below concern document(s) or information included:		
<ol style="list-style-type: none"> 11. <input checked="" type="checkbox"/> Information Disclosure Statement (IDS) w/PTO-1449 - <input type="checkbox"/> Copy of IDS citations 12. <input type="checkbox"/> Assignment Papers (cover sheet & document(s)) 13. <input checked="" type="checkbox"/> A FIRST Preliminary Amendment. 14. <input type="checkbox"/> A SECOND or SUBSEQUENT Preliminary Amendment. 15. <input type="checkbox"/> A substitute specification. 16. <input type="checkbox"/> A change of power of attorney and/or address letter. 17. <input type="checkbox"/> A computer-readable form of the sequence listing in accordance with PCT Rule 18. <input type="checkbox"/> A second copy of the published international application under 35 U.S.C. 154(d)(4). 19. <input type="checkbox"/> A second copy of the English language translation of the international application (35 U.S.C. 154(d)(4)). 20. <input checked="" type="checkbox"/> Other items or information: INTERNATIONAL PRELIMINARY EXAMINATION REPORT (PCT/IPEA/409), INTERNATIONAL SEARCH REPORT (PCT/ISA/210), APPLICATION DATA SHEET, ABSTRACT 		

JC13 Rec'd PCT/PTO 04 MAR 2002

U.S. APPLICATION NO. 10/070250		INTERNATIONAL APPLN. NO. PCT/NL00/00618		ATTORNEY DOCKET NO. 2004-1001	
21. <input checked="" type="checkbox"/> The following fees are submitted: BASIC NATIONAL FEE (37 CFR 1.492 (a) (1)-(5): Neither international preliminary examination fee nor international search fee paid to USPTO and international Search Report not prepared by the EPO or JPO.....\$1040.00 International preliminary examination fee not paid to USPTO but International Search Report prepared by the EPO or JPO\$890.00 International preliminary examination fee not paid to USPTO but International search fee paid to USPTO\$740.00 International preliminary examination fee paid to USPTO but all claims did not satisfy provision of PCT Article 33 (1)-(4)\$710.00 International preliminary examination fee paid to USPTO and all claims satisfied provision of PCT Article 33 (1)-(4)\$100.00 ENTER APPROPRIATE BASIC FEE AMOUNT				CALCULATIONS PTO USE ONLY	
				\$ 890.00	
Surcharge of \$130.00 for furnishing the oath or declaration than <input type="checkbox"/> 20- <input checked="" type="checkbox"/> 30 Months from the earliest claimed priority date (37 CFR 1.492(e))				\$ 130.00	
CLAIMS	NUMBER FILED	NUMBER EXTRA	RATE		
Total Claims	18 - 20 =	0	X \$18.00	\$	
Independent Claims	3 - 3 =	0	X \$84.00	\$	
MULTIPLE DEPEND CLAIM(S) (if applicable)			+ \$280.00	\$	
TOTAL OF ABOVE CALCULATION -				\$ 1020.00	
<input type="checkbox"/> Applicant claims small entity status. See 37 CFR 1.27. The fees indicated above are reduced by 1/2.				+	
SUBTOTAL =				\$ 1020.00	
Processing fee of \$130.00 for furnishing the English translation later than <input type="checkbox"/> 20 <input type="checkbox"/> 30 months from the earliest claimed priority date (37 CFR 1.492Z(f)).				\$	
TOTAL NATIONAL FEE =				\$ 1020.00	
Fee for recording the enclosed assigned (37 CFR 1.21(h)). The assignment must be accompanied by an appropriate cover sheet (37 CFR 3.28, 3.31) \$40.00 per property +				\$	
TOTAL FEES ENCLOSED -				\$ 1020.00	
				Amount to be refunded:	\$
				Charged:	\$
<input checked="" type="checkbox"/> A Check in the amount of \$1,020.00 to cover all fees is attached. <input type="checkbox"/> The Commissioner is hereby authorized to charge indicated fees and credit any overpayments to Deposit account No. 25-0120 in the name of Young & Thompson, as described below. A duplicate copy of this sheet is enclosed. <input checked="" type="checkbox"/> The Commissioner is hereby authorized in this, concurrent, and future replies, to charge payment or credit any overpayment to Deposit Account No. 25-0120 for any additional fee required under 37 C.F.R. §§ 1.16 or 1.17.					
SEND ALL CORRESPONDENCE TO: 745 South 23 rd Street Arlington, VA 22202 Telephone (703) 521-2297 Y&T Customer No. 000466			<div style="text-align: center;">  SIGNATURE </div> <div style="text-align: center;"> Benoit Castel NAME </div> <div style="text-align: center;"> 35,041 REGISTRATION NO. </div>		
BC/bam Date: March 4, 2002					

PATENT
2004-1001

IN THE U.S. PATENT AND TRADEMARK OFFICE

In re application of: Adriaan VAN KRIEKEN et al.

Appl. No.: **NEW NATIONAL PHASE
APPLICATION IN THE
UNITED STATES** Group:

Filed: March 4, 2002 Examiner:

For: METHOD FOR PROVIDING TEXTURES ON PRODUCTS

PRELIMINARY AMENDMENT

Assistant Commissioner for Patents
Washington, DC 20231

March 4, 2002

Sir:

Prior to the first Official Action and calculation of the filing fee, the following preliminary amendments and remarks are respectfully submitted in connection with the above-identified application.

IN THE SPECIFICATION:

Please substitute page 1 as originally filed, with pages 1 and 1a as filed in the Article 34 amendment of November 23, 2001. Pages 1 and 1a are marked "AMENDED SHEET" and are attached hereto.

IN THE CLAIMS:

Please substitute claims 1-18 as originally filed, which appear on pages 8-10, with claims 1-18 as filed in the Article 34 amendment of November 23, 2001. The pages containing claims 1-18 are marked "AMENDED SHEET" and are attached hereto. Following the insertion of claims 1-18, please amend the claims as follows:

Please amend the claims as follows:

--3.(Amended) A method according to claim 1, which comprises providing the superimposed grids in a rotated position with respect to each other around a common point on the relevant surface.

6.(Amended) A method according to claim 1, which comprises providing the grids by means of a laser, built up from mainly point-shaped deformations.

8.(Amended) A method according to claim 1, which comprises providing a series of grids at least partly overlapping each other such that an irregularly looking pattern of deformations, but built up from regular grids, is obtained on the relevant product part.

9.(Amended) A method according to claim 1, which comprises forming for each deformation a central depression and an edge extending around it, raised with respect to the relevant surface.

10.(Amended) A method according to claim 1, which comprises providing the texture on at least part of a forming tool, after which a product is formed, at least processed, with the relevant forming tool, such that a negative impression of the texture is obtained on at least part of the relevant product.

12.(Amended) A method according to claim 6, in which a protective gas is used.

17.(Amended) A method for repairing texture, obtained with a method according to claim 1, which comprises clamping the product or product part on which the texture is provided, in a suitable apparatus, which apparatus at least comprises deformation means and deformation means control means, inputting in the deformation means control means of one of the grids the position and the coordinates with respect to a reference point, as well as the displacements enclosed between the grids, in particular angles of rotation, after which by means of the at least one deformation means the different

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grids are repaired or provided again, at least as far as
necessary, such that the original texture is nearly completely
repaired.--

REMARKS

Claims 1-18 have been amended to eliminate multiple dependencies.

The substitution of claims 1-18 and page 1 of the specification has been done to merely place this national phase application in into the same condition as it was during Chapter II of the International Phase.

Entry of the above amendments is earnestly solicited. An early and favorable first action on the merits is earnestly requested.

Should there be any matters that need to be resolved in the present application, the Examiner is respectfully requested to contact the undersigned at the telephone number listed below.

Attached hereto is a marked-up version of the changes made to the claims by the current amendment. The attached page is captioned "VERSION WITH MARKINGS TO SHOW CHANGES MADE."

The Commissioner is hereby authorized in this, concurrent, and future replies, to charge payment or credit any overpayment to Deposit Account No. 25-0120 for any additional fees required under 37 C.F.R. § 1.16 or under 37 C.F.R. § 1.17.

Respectfully submitted,
YOUNG & THOMPSON



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BC/bam
Attachments

VERSION WITH MARKINGS TO SHOW CHANGES MADE

IN THE CLAIMS:

The claims have been amended as follows:

3. (Amended) A method according to claim 1 ~~or 2~~, which comprises providing the superimposed grids in a rotated position with respect to each other around a common point on the relevant surface.

6. (Amended) A method according to ~~any one of the preceding claims,~~ claim 1, which comprises providing the grids by means of a laser, built up from mainly point-shaped deformations.

8. (Amended) A method according to ~~any one of the preceding claims,~~ claim 1, which comprises providing a series of grids at least partly overlapping each other such that an irregularly looking pattern of deformations, but built up from regular grids, is obtained on the relevant product part.

9. (Amended) A method according to ~~any one of the preceding claims,~~ claim 1, which comprises forming for each deformation a central depression and an edge extending around it, raised with respect to the relevant surface.

10. (Amended) A method according to ~~any one of the preceding claims,~~claim 1, which comprises providing the texture on at least part of a forming tool, after which a product is formed, at least processed, with the relevant forming tool, such that a negative impression of the texture is obtained on at least part of the relevant product.

12. (Amended) A method according to ~~any one of claims 6-11,~~claim 6, in which a protective gas is used.

17. (Amended) A method for repairing texture, obtained with a method according to ~~any one of claims 1-12 or on a product according to any one of claims 13-15,~~claim 1, which comprises clamping the product or product part on which the texture is provided, in a suitable apparatus, which apparatus at least comprises deformation means and deformation means control means, inputting in the deformation means control means of one of the grids the position and the coordinates with respect to a reference point, as well as the displacements enclosed between the grids, in particular angles of rotation, after which by means of the at least one deformation means the different grids are repaired or provided again, at least as far as necessary, such that the original texture is nearly completely repaired.

(12) INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(19) World Intellectual Property Organization
International Bureau



(43) International Publication Date
15 March 2001 (15.03.2001)

PCT

(10) International Publication Number
WO 01/17754 A1

(51) International Patent Classification⁷: **B29C 59/02**

(21) International Application Number: PCT/NL00/00618

(22) International Filing Date:
4 September 2000 (04.09.2000)

(25) Filing Language: Dutch

(26) Publication Language: English

(30) Priority Data:
1012972 3 September 1999 (03.09.1999) NL

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(81) Designated States (national): AE, AG, AL, AM, AT, AU,
AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CR, CU, CZ,
DE, DK, DM, DZ, EE, ES, FI, GB, GD, GE, GH, GM, HR,
HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR,
LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ,
NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM,
TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW.

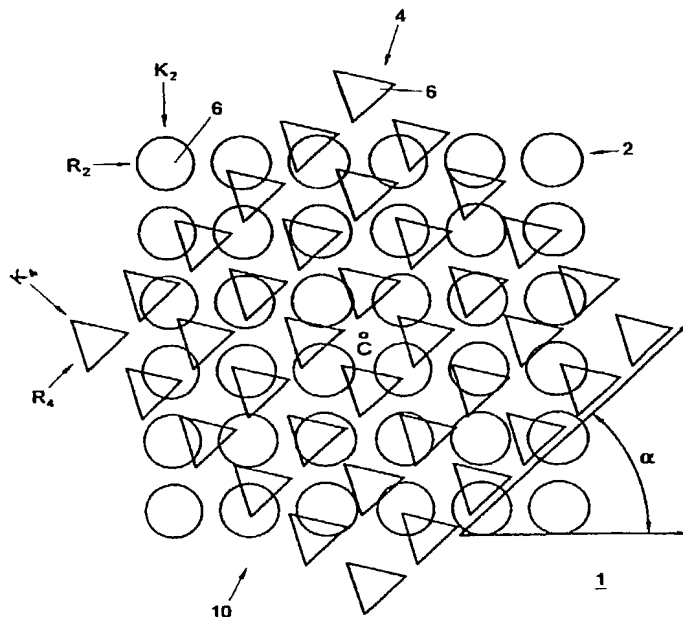
(84) Designated States (regional): ARIPO patent (GH, GM,
KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZW), Eurasian
patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European
patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE,
IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG,
CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).

Published:

— With international search report.

[Continued on next page]

(54) Title: METHOD FOR PROVIDING TEXTURES ON PRODUCTS



(57) Abstract: A method for providing texture on a product part, which comprises providing on the relevant product part a first grid (2), formed from a pattern of rows and columns of deformations of the surface of the relevant product part, placing over the first grid (2) at least a second grid (4), which is comparable to and preferably equal to the first grid (2), the deformations of the second grid (4) at least partly overlapping the deformations of the first grid (2).

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Title: Method for providing textures on products

The invention relates to a method for providing texture on a product part. Such a method is known from practice.

To obtain, for instance, a pleasant appearance or a suitable roughness of the surface of a product, there are used methods for providing texture thereon, which comprise providing patterns in relief on the relevant product, at least product part. To this end, patterns of depressions or differently shaped deformations of the surface of the relevant product part are provided, for instance, by means of mechanical or optical means. These deformations afford a texture. The deformations may be provided directly on a part of a consumer article but may, for instance, also be made in a die, such that when forming products in the relevant die, the desired structure is transferred to parts of products formed in the die.

In the known method, regular or irregular patterns of depressions are provided in one operating cycle. There is thus obtained a texture having at least one clear direction of orientation, which is often undesirable, since this results in a texture having a less pleasant appearance. Proposals have already been made to provide the deformations randomly, so as to prevent directions of orientation from remaining visible in the texture. This, true, ensures a more pleasant appearance of the relevant product part, but repair of the relevant texture is no longer possible, in view of the random distribution. This means that in particular when texture is provided in a die, repair of the die when, for instance, it has become worn or otherwise damaged, is substantially impeded, if not made impossible.

JP 09193245 discloses a method for obtaining varicolored moiré patterns on translucent plastic sheet extruded from a T-die by a first embossing roll and a second embossing roll, in which continuously a second embossing is superposed on a first embossing. In this known method the plastic sheet to which the first embossing is applied is slightly contracted in its width direction. As a result of applying tension to the plastic sheet the original first embosses are crushed at parts where ridges and valleys collide with each other. Further, parts where embosses are crushed by the fluctuations of a tensile speed are changed to the left and right of the sheet and irregular moiré patterns are developed. The moiré patterns obtained by

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new page 1a

this method are, due to the properties of the plastic sheet random and not reproducible.

EP 0 462 439 discloses a method for suppressing negative interference on photosensitive films. A substrate having a rough surface is used such that light falling on a top surface is dispersed thereon. Laser technique can be used for providing said rough surface, by providing one regular pattern of crisscross grooves.

The object of the invention is to provide a method of the type described in the introduction, in which the above drawbacks are avoided, while retaining the advantages thereof. To this end, a method according to the present invention is characterized by the measures according to claim 1.

By using grids of rows and columns of deformations, in which at least two grids are provided in a displaced position with respect to each other, there is obtained the advantage that the undesirable directions of orientation can be prevented from remaining visible. The term displaced as used herein should be understood as at least comprising linear displacements and in particular rotations, as well as combinations thereof.

The density of the deformations and the positions of the rows and/or columns of the relevant grids, at least of the deformations therein, can be displaced with respect to each other such that an at least visually slightly random distribution of the deformations is obtained. Moreover, interference patterns can thus be prevented or, on the other hand, be stressed. In this connection, it is preferable that the deformations of a first grid are at least partly overlapped by deformations of the second grid, which has the result that the random impression of the texture is further increased. By using grids having a regular known distribution of the deformations, there is obtained the advantage that in a very simple manner repair of the relevant grids and hence of the texture is possible. In fact, this only requires that the position of the relevant grid is again equally adjusted. This has the result that the service life of, for instance, dies can be substantially increased, that the reproducibility of the product parts, at least the texture thereon, can be substantially improved, and that, moreover, there is obtained a very great freedom of generating texture, starting from very simple patterns.

When forming deformations and depressions, material can also be removed, if required.

In a further elaboration, a method according to the present invention is further characterized by the measures according to claim 3.

Surprisingly, it has been found that exactly rotation of at least one of the grids with respect to at least one of the other grids leads to texture having a very pleasant appearance. Viewed from the center of rotation, the distances between deformations of a first grid and deformations in a second grid rotated with respect thereto will change in relation to the distance from the relevant deformations to the above center of rotation, which, moreover, results in different degrees of overlap of deformations. This will still further increase the random appearance of the texture, while the reproducibility remains the same.

In a very advantageous embodiment, a method according to the present invention is further characterized by the measures according to claim 5.

It has been found that when five, preferably equal grids are used, which are always rotated with respect to each other through an angle of 36° or a multiple thereof, a very advantageous texture is obtained. This texture has a very pleasant appearance, in particular because no direction of

orientation is visible therein anymore and interference patterns are maximally prevented, while such a texture is excellently reproducible.

In a method according to the present invention, a laser is preferably used to provide the deformations, which deformations are preferably point-shaped. It will be clear, however, that other methods may also be suitable for providing deformations, for instance mechanical operations, in which the deformations may additionally be differently shaped, for instance line-shaped.

In a further elaboration, a method according to the present invention is characterized by the measures according to claim 9.

By carrying out the deformations as a central depression with an edge raised from the surface positioned around it, there is obtained a texture of the type described above, in which, moreover, the roughness of the surface is slightly increased. Besides, this can further improve the random appearance of the texture. Such deformations can be simply obtained, for instance, by using a suitable laser. The selection and adjustment of such a laser will be immediately clear to those skilled in the art.

In a preferred embodiment, a method according to the present invention is further characterized by the measures according to claim 10.

Exactly by providing a texture according to the present invention on a forming tool, such as a die, a punch, a vacuum mold or the like, there is obtained the advantage that the resulting texture can be transferred to a large number of products in a very simple manner. As a result of the selected texture, maintenance and repair of the relevant forming tool is possible in a simple manner.

The invention further relates to a product provided with a texture, characterized by the measures according to claim 13.

The invention further relates the use of a laser for providing texture on a product part, characterized by the measures according to claim 16.

The invention also relates to the use of a method for repairing texture, characterized by the measures according to claim 17.

Further advantageous embodiments of a method, product and use according to the invention are given in the subclaims. In explanation, exemplary embodiments of a method, apparatus and use according to the

comprises, in a matrix comparable to that of the first grid 2, rows R4 and columns K4 of depressions 6, which are mainly equal to the depressions 6 in the first grid 2. The second grid 4 is rotated with respect to the first grid 2 through an angle α , in the embodiment shown, for instance, approximately 45°. As a result thereof, the depressions 6 of the first grid 2 will be at least partly covered by the depressions 6 of the second grid 4. In the ready texture 10, formed by the grids 2, 4, this results in composite, irregularly formed depressions, which afford the texture 10 a semi-random appearance, mainly without interference patterns, while the texture 10 is simply reproducible. In fact, the regular grids 2, 4 can be simply repaired or reproduced, while the angle α enclosed between the grids 2, 4 is unambiguously determined, as is the center of rotation C. When the die has become worn, the texture 10 can therefore be simply repaired, as a result of which products having a constant quality can permanently be manufactured in the relevant die.

Fig. 2 shows a texture 10, built up from five grids, comparable to those shown in Fig. 1. In this embodiment, a first grid 102 is represented in Fig. 2 by a matrix of squares. A second grid 104, represented by circles, a third grid 112, represented by octagons, a fourth grid 114, represented by triangles, and a fifth grid 116, represented by hexagons, are placed over it. Each of the grids 102, 104, 112, 114, 116 is built up from rows R and columns K of depressions 106, the depressions of all grids being the same. Only for the purpose of explanation, they are shown in the figure as differently shaped. Incidentally, it is observed that the depressions 6 of different grids may also be of a different kind, for further adaptation of the texture 10, 110. The second grid 104 is rotated around a point C with respect to the first grid 102 through an angle α_2 . This means that the rows R and the columns K of the second grid 104 enclose an angle α_2 with respectively the rows R and columns K of the first grid 102. In a comparable manner, the third grid 112, the fourth grid 114, and the fifth grid 116 are rotated with respect to the first grid 102 around the point C through respectively a third angle α_3 , a fourth angle α_4 , and a fifth angle α_5 . The first grid 102 defines a base angle α_1 , represented in Fig. 2 by a horizontal line, which means that the angle α_1 is set at 0°. In the example shown in Fig. 2, there is selected a very favorable distribution of the angles, i.e. α_2 is 36°, α_3 is 72°, α_4 is 108°, and α_5 is 144°, starting from α_1 is 0°. There is thus

obtained a texture 110, built up from regular grids, which texture has a random appearance and is yet properly reproducible. In fact, for each of the grids only one starting position needs to be fixed.

It will be clear that by using more or fewer grids and/or by using
5 other enclosed angles, other distributions of the depressions 6, 106 and hence other textures are obtained. Precisely in the embodiment shown in Fig. 2, it has been found, surprisingly, that none, at least minimal interference patterns occur, which makes such a texture excellently useful. As already observed, by means of a suitable selection of the deformation
10 technique, in particular the selection of specific laser techniques, the energy to be introduced, the starting material and, optionally, the use of protective gases, the shape of each depression 6, 106 can be optimized. Thus, for instance, such deformation can be effected that none or only a minimal raised edge 8 is obtained, which results in a relatively smooth texture. In
15 particular the use of a protective gas can influence the flow pattern positively. Also, material may be removed, for instance by combustion, sublimation and the like.

In the exemplary embodiments shown in Figs. 1 and 2, there is rotation of the different grids around a central point C. It will be clear,
20 however, that rotations of a different kind and combined rotation-translation movements are also possible to obtain comparable (semi-) random textures, which are properly reproducible.

Figs. 3A-H show a number of examples of textures manufactured on a steel surface suitable for injection molding of plastic. For this an Nd:YAG
25 laser is used, while applying argon as protective gas. Table 1 gives a number of setting values for each of the examples shown. As appears from Table 1, the examples as shown in Figs. 3A-F have been carried out according to Fig. 2, the example as shown in Fig. 3G has been carried out as shown in Fig. 1, with an angle α of 90° and with a distance between the
30 columns which is regular but deviates from the regular distance between the rows. The exemplary embodiment as shown in Fig. 3G is made with four grids rotated with respect to each other at regular angles.

sample pulse no.	duration ms	RMS value mv	pulse freq. Hz	spot size micro- meter	spacing micro- meter	laser configuration cavity mm	voltage	focus mm above surface	degrees per step
1 (3A)	0.075	43	300	20	50	2.4	100%	6	Random m.
2 (3B)	0.25	84	100	110	300	2.4	100%	3	Random m.
3 (3C)	0.25	84	100	125	400	2.4	100%	2.5	Random m.
4 (3D)	0.25	84	100	160	300	2.4	100%	1	Random m.
5 (3E)	0.075	46	300	65	180	2.4	100%	0	Random m.
6 (3F)	0.075	46	300	80	230	2.4	100%	2	Random m.
7 (3G)	0.075	46	300	80 Sp.	500/507	2.4	100%	2	Degr.0&90
8 (3H)	0.075	46	300	65	230	2.4	100%	0	Degr.0,2,4,6

The exemplary embodiments shown in the drawings should by no means be regarded as limitative. Thus, other lasers may be used, in particular pulsating lasers, while, moreover, other protective gases may be used, for instance helium CO₂, N₂, Ar, and mixtures thereof. By means of the protective gases the material is protected from oxidation, and the flow behavior of the molten material is influenced. Moreover, influencing of the plasma thereby occurs. As a result thereof, the amount of energy supplied to the material is influenced, as is the temperature which the material can reach under the influence of the laser.

A texture according to the present invention is particularly suitable for being provided in a molding die or on, for instance, a punching or pressing tool, but can also be provided directly on a consumer article. The depressions of the different grids may advantageously all be identical, but it is also possible to provide different depressions for the different grids, to further influence the texture. Although, in the exemplary embodiments shown, the texture is provided circularly, it will be clear that any regular or irregular contour may be obtained for the texture, while such a texture may be provided both on flat and on single- or double-curved surfaces. These and many comparable variations are deemed to fall within the scope of the invention defined by the claims.

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new page 8

NEW CLAIMS

1. A method for providing texture on a product part, which comprises:
 - providing in a first step on a relevant product part a first grid, formed from a pattern of rows and columns of spaced apart deformations of the surface of the relevant product part,
 - placing in a second step over the first grid at least a second grid having spaced apart deformations, which is comparable to and preferably equal to the first grid,
 - the deformations of the second grid at least partly overlapping the deformations of the first grid
 - 10 - the first and second grids and their relative positions being reproducible.
2. A method according to claim 1, which comprises superimposing a series of more than two identically shaped, preferably equal grids, the deformations of a superjacent grid always at least partly overlapping the
15 deformations of subjacent grids.
3. A method according to claim 1 or 2, which comprises providing the superimposed grids in a rotated position with respect to each other around a common point on the relevant surface.
4. A method according to claim 3, in which each grid is rotated with
20 respect to a superjacent or subjacent grid through an angle of 36° .
5. A method according to claim 4, which comprises superimposing five grids, an angle of $N \cdot 36^\circ$ always being enclosed between two grids, N being a natural number.
6. A method according to any one of the preceding claims, which
25 comprises providing the grids by means of a laser, built up from mainly point-shaped deformations.

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7. A method according to claim 6, which comprises building up the grids from rows and columns of point-shaped deformations.
8. A method according to any one of the preceding claims, which comprises providing a series of grids at least partly overlapping each other such that an irregularly looking pattern of deformations, but built up from regular grids, is obtained on the relevant product part.
9. A method according to any one of the preceding claims, which comprises forming for each deformation a central depression and an edge extending around it, raised with respect to the relevant surface.
10. A method according to any one of the preceding claims, which comprises providing the texture on at least part of a forming tool, after which a product is formed, at least processed, with the relevant forming tool, such that a negative impression of the texture is obtained on at least part of the relevant product.
11. A method according to claim 10, in which the forming tool is a die, in particular a molding die.
12. A method according to any one of claims 6 - 11, in which a protective gas is used.
13. A product, provided with a texture on at least part of its surface, which texture is built up from a number of superimposed grids of deformations of the relevant part of the surface, said deformations at least partly overlapping each other, wherein each grid is formed by spaced apart, individual deformations having a regular pattern.
14. A product according to claim 13, which product is at least part of a forming tool.
15. A product according to claim 13, which product is at least part of a consumer article, in particular a product manufactured by injection molding.

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16. Use of a laser for providing texture on a product part, in the form of a series of grids overlapping each other, each grid built up from a matrix of rows and columns of individual, spaced apart surface deformations.

17. A method for repairing texture, obtained with a method according to any one of claims 1 - 12 or on a product according to any one of claims 13 - 15, which comprises clamping the product or product part on which the texture is provided, in a suitable apparatus, which apparatus at least comprises deformation means and deformation means control means,

inputting in the deformation means control means of one of the grids the position and the coordinates with respect to a reference point, as well as the displacements enclosed between the grids, in particular angles of rotation, after which by means of the at least one deformation means the different grids are repaired or provided again, at least as far as necessary, such that the original texture is nearly completely repaired.

18. A method according to claim 17, in which the deformation means used is a laser.

ABSTRACT

A method for providing texture on a product part, which comprises providing on the relevant product part a first grid (2), formed from a pattern of rows and columns of deformations of the surface of the relevant product part, placing over the first grid (2) at least a second grid (4), which is comparable to and preferably equal to the first grid (2), the deformations of the second grid (4) at least partly overlapping the deformations of the first grid (2).

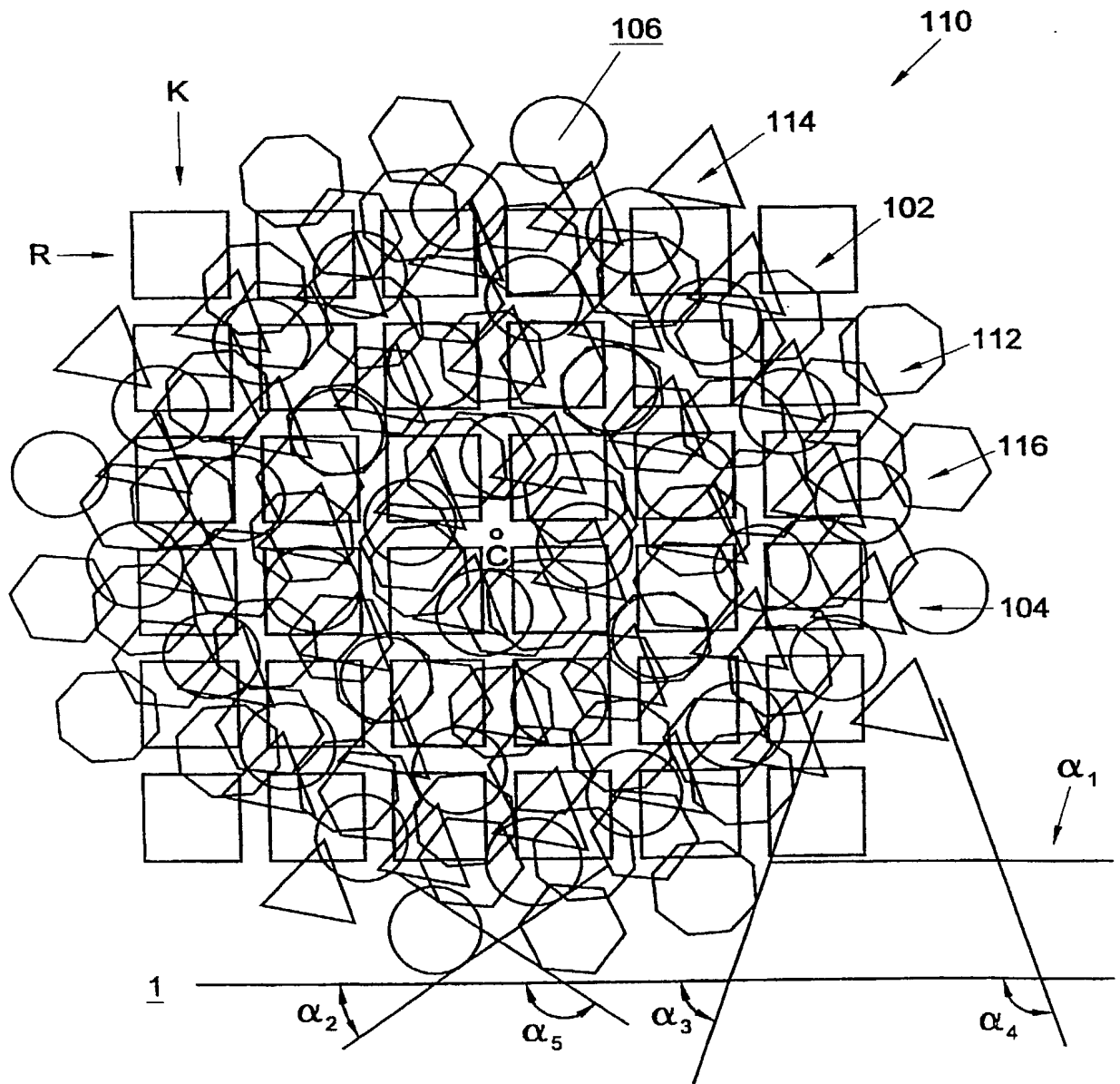


Fig. 2

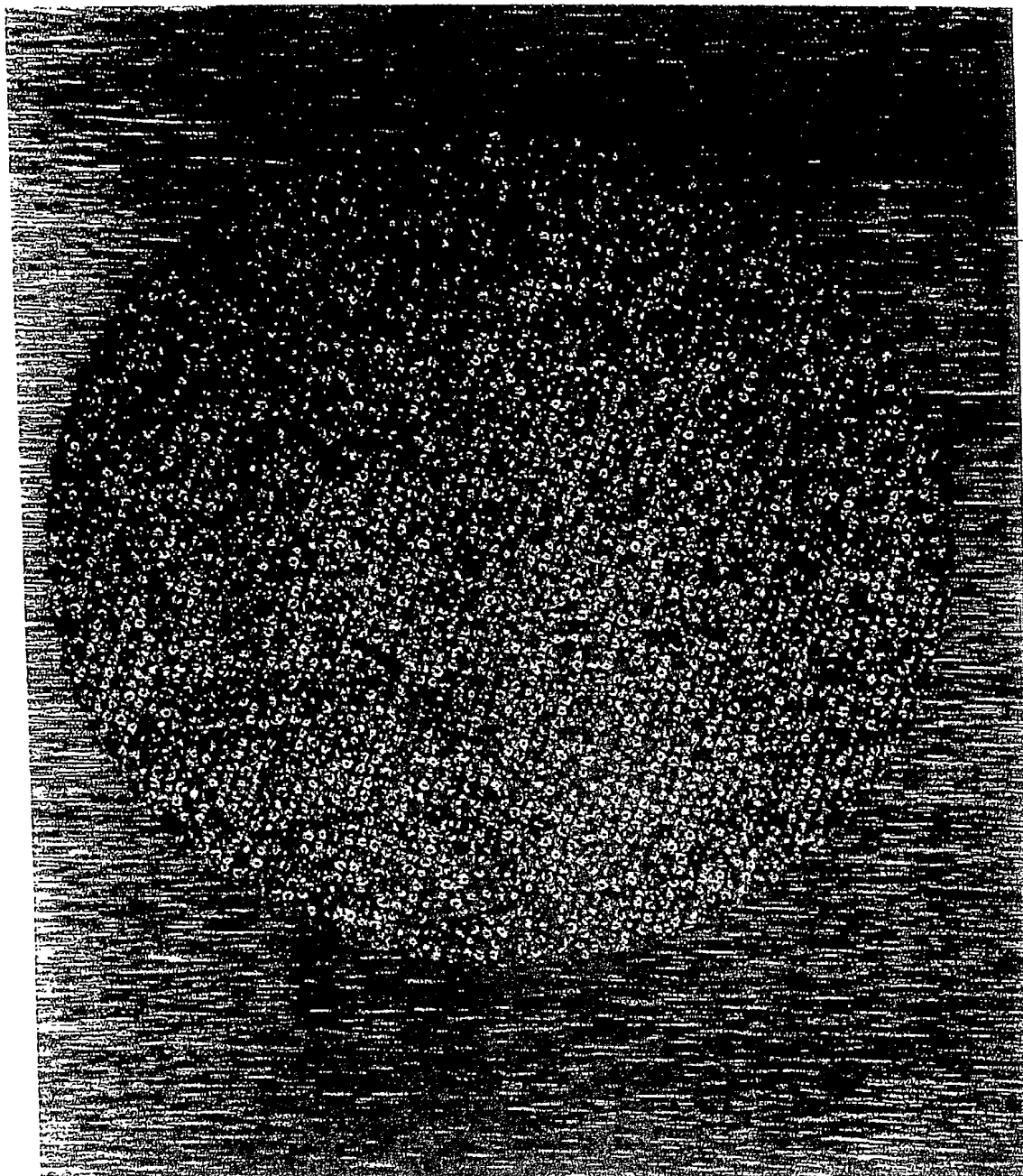


Fig. 3A

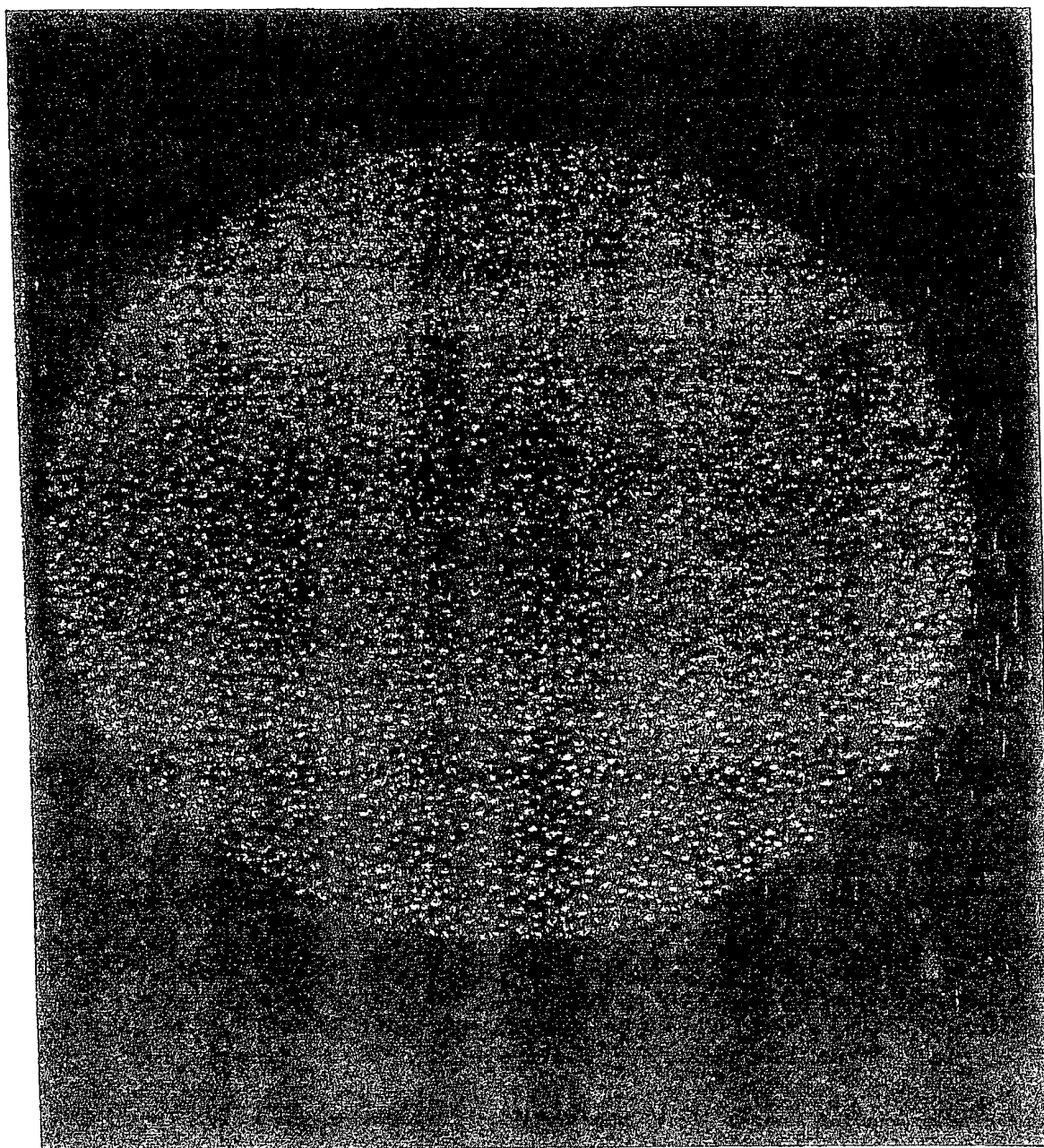


Fig. 3B

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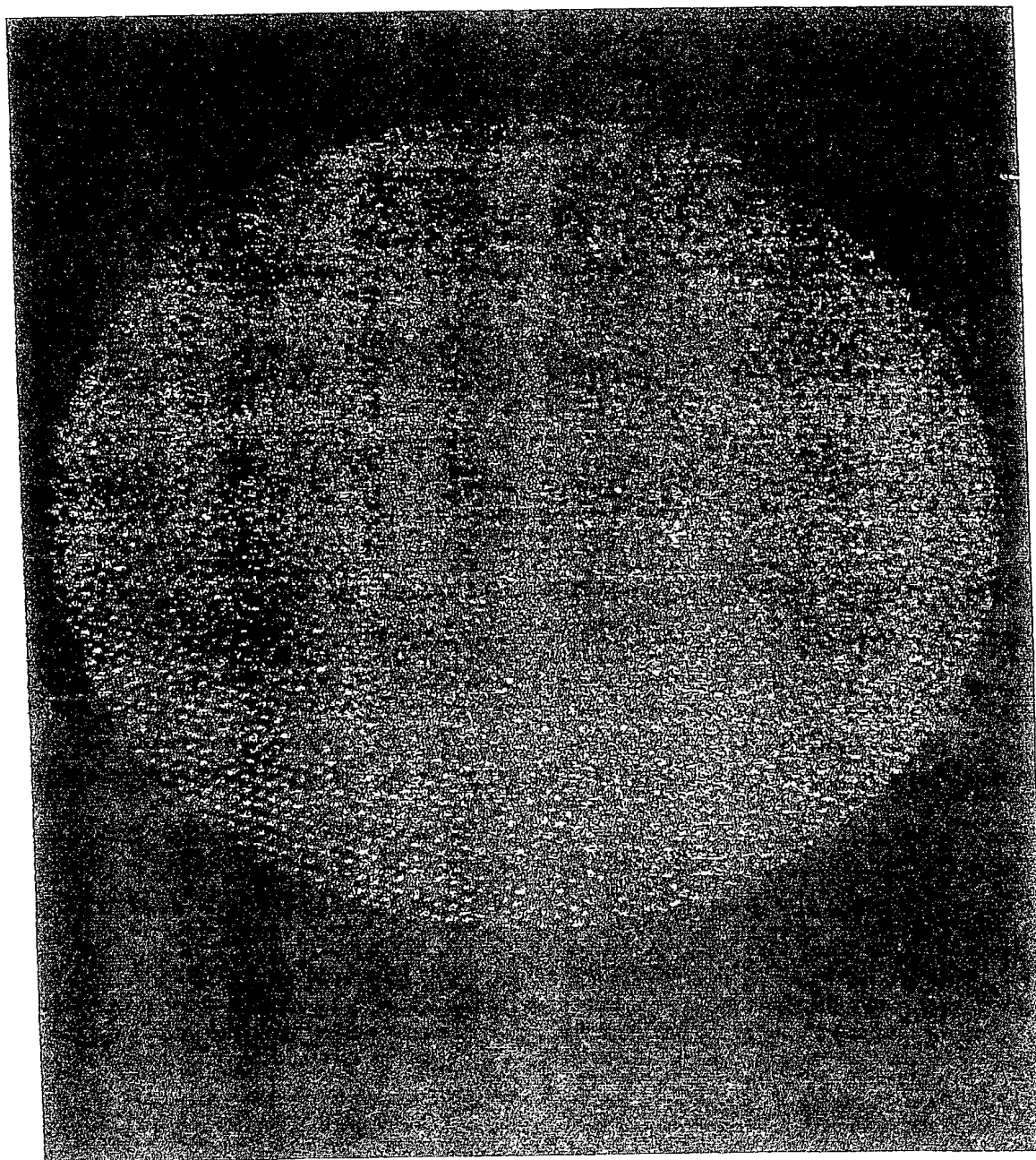


Fig. 3C

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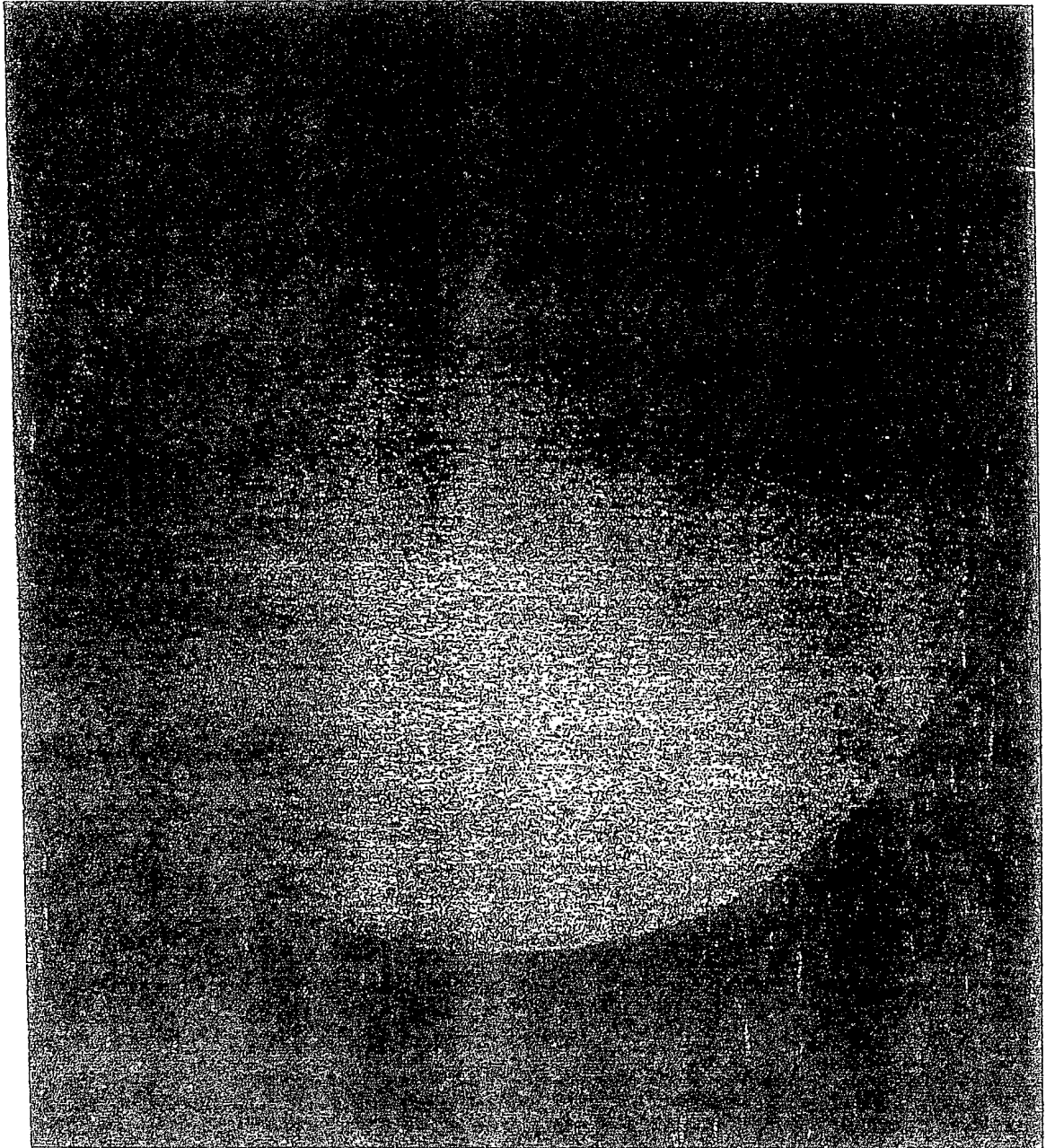


Fig. 3D

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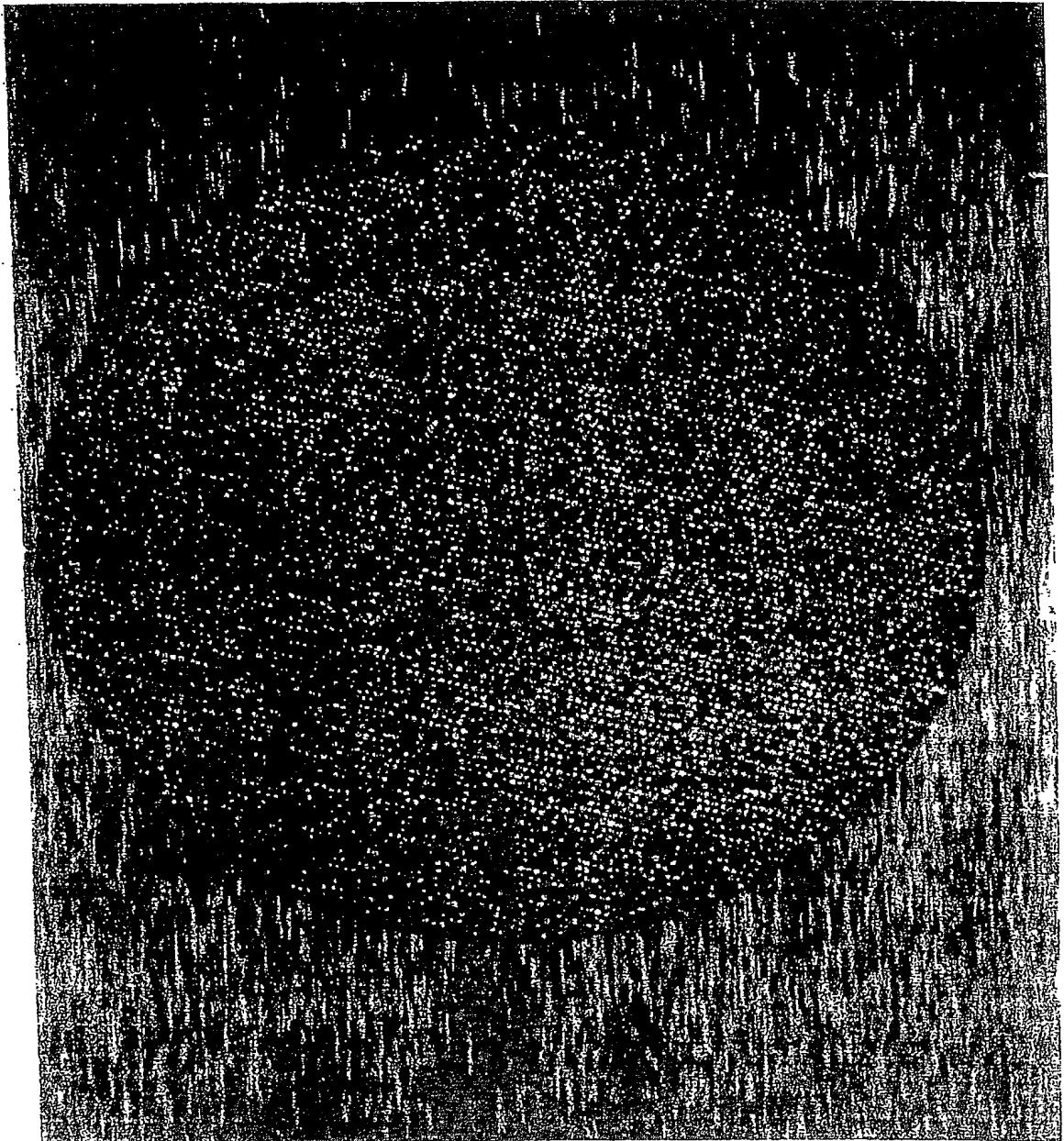


Fig. 3E

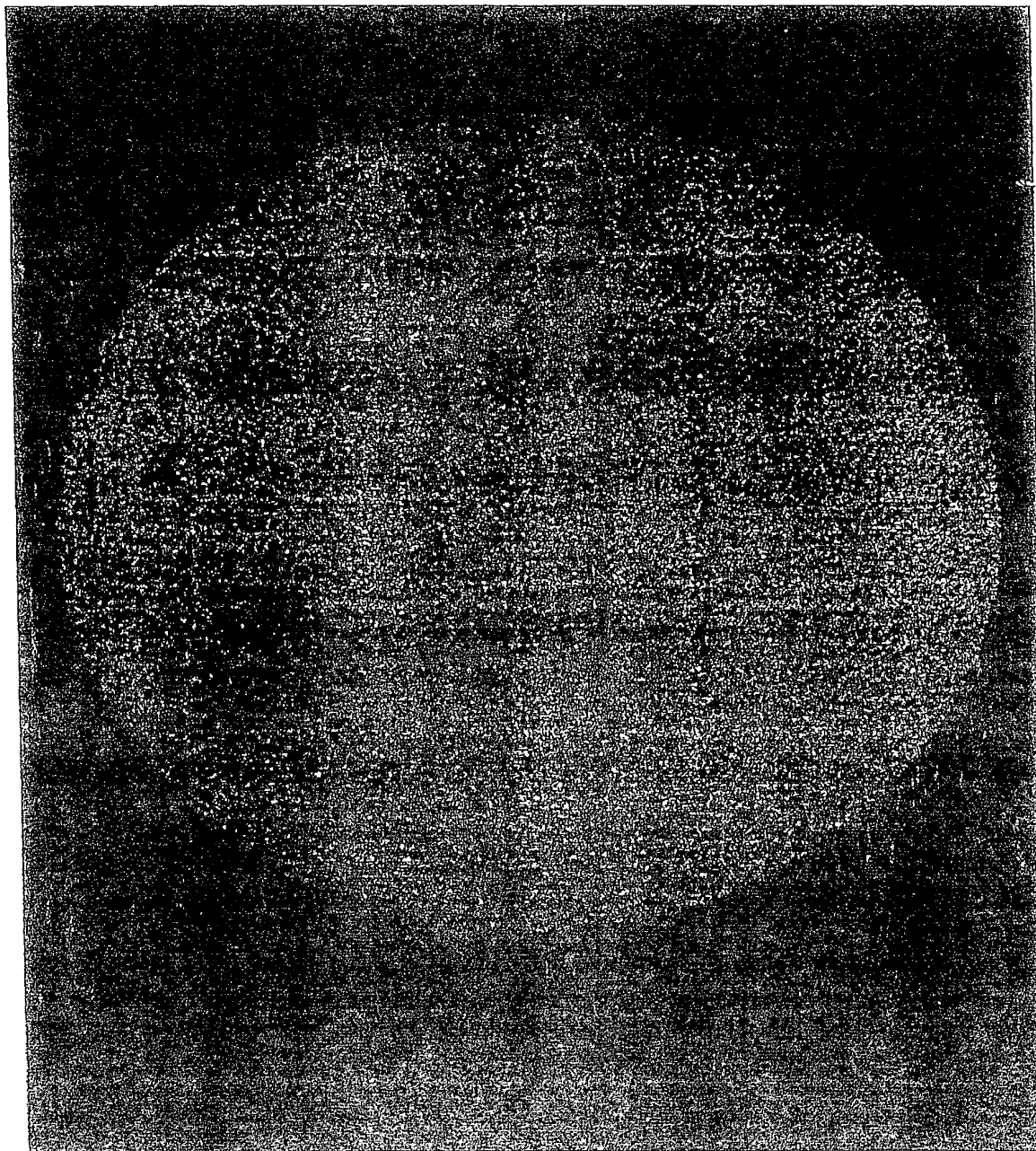


Fig. 3F

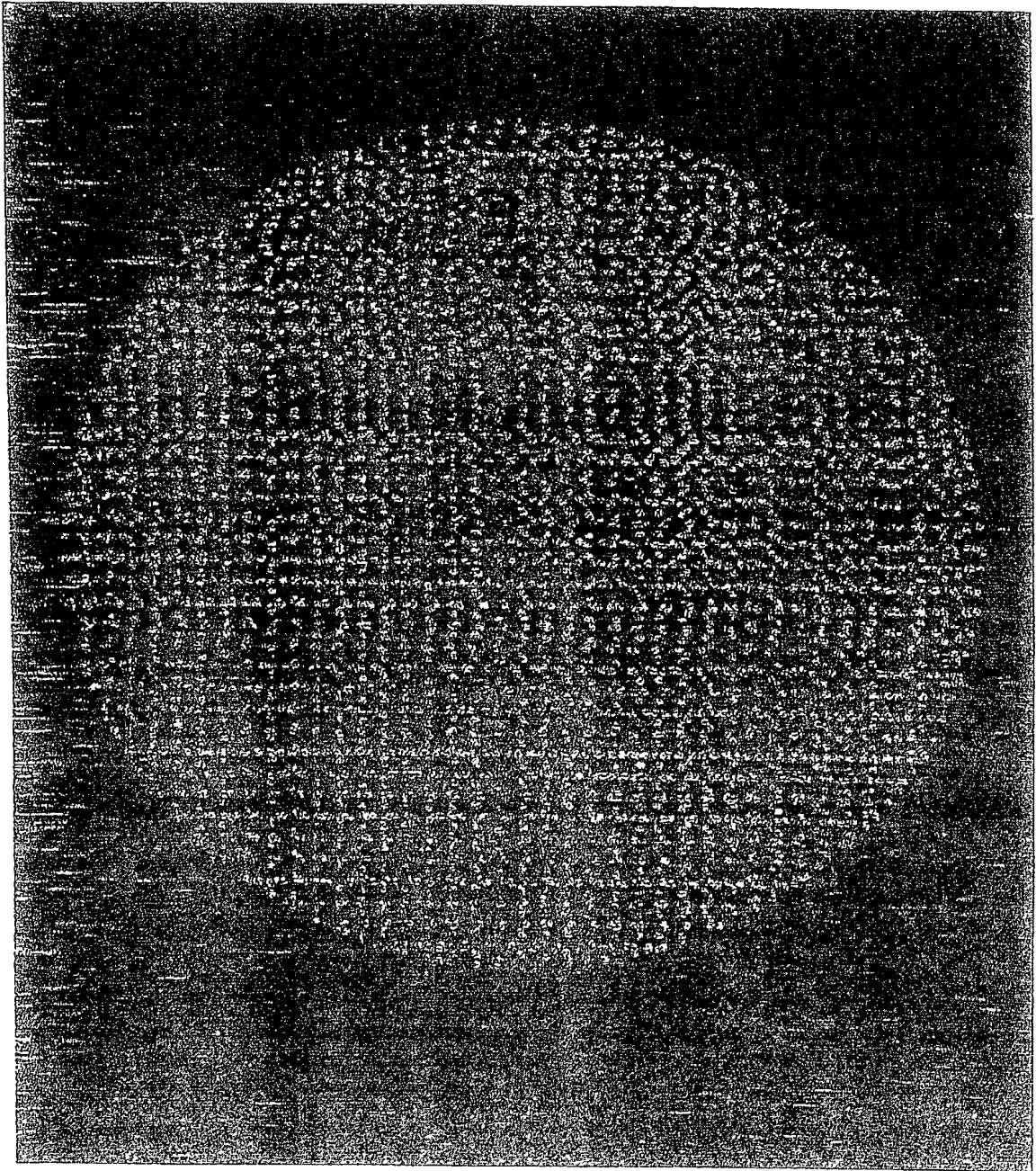


Fig. 3G

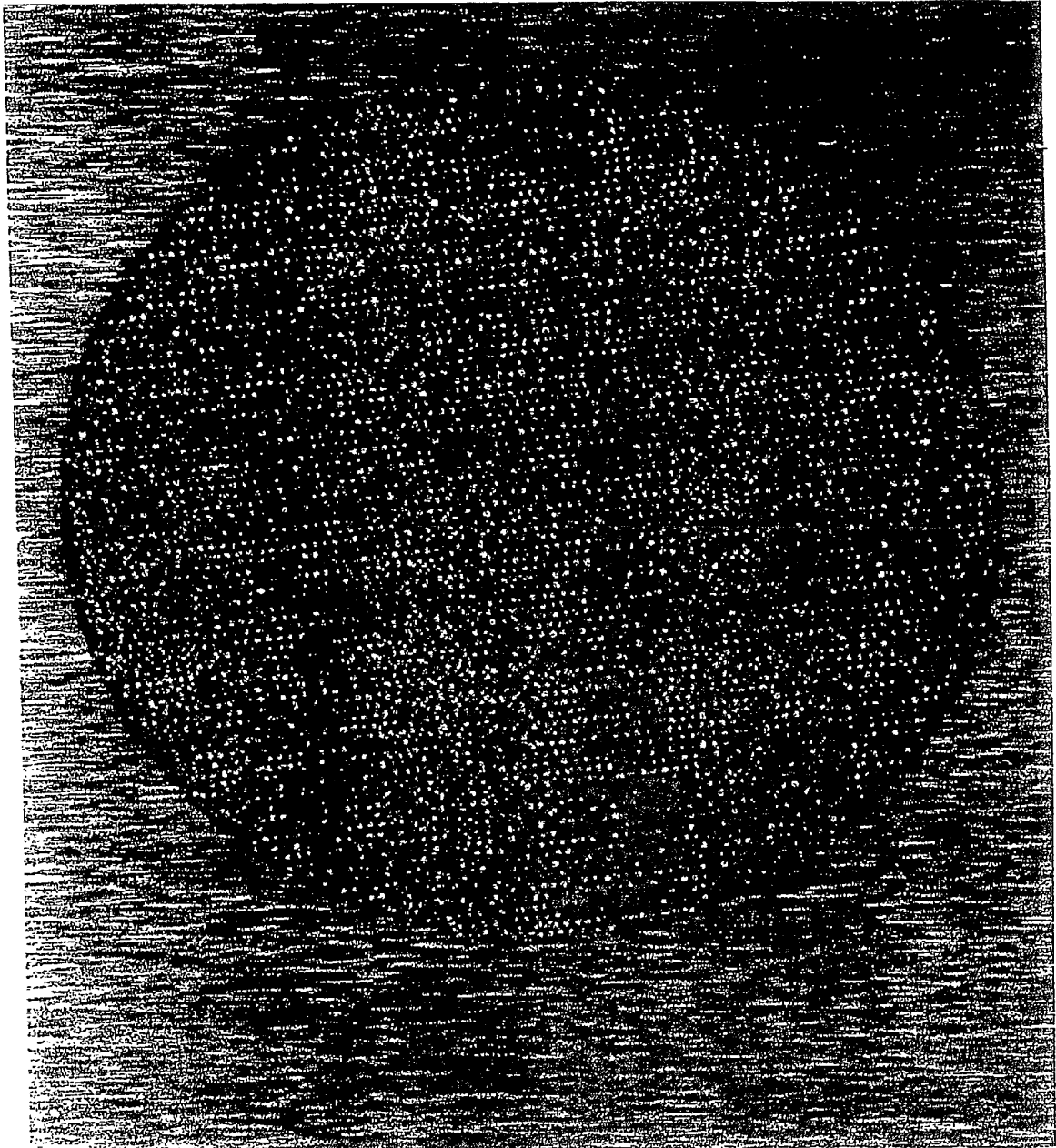


Fig. 3H

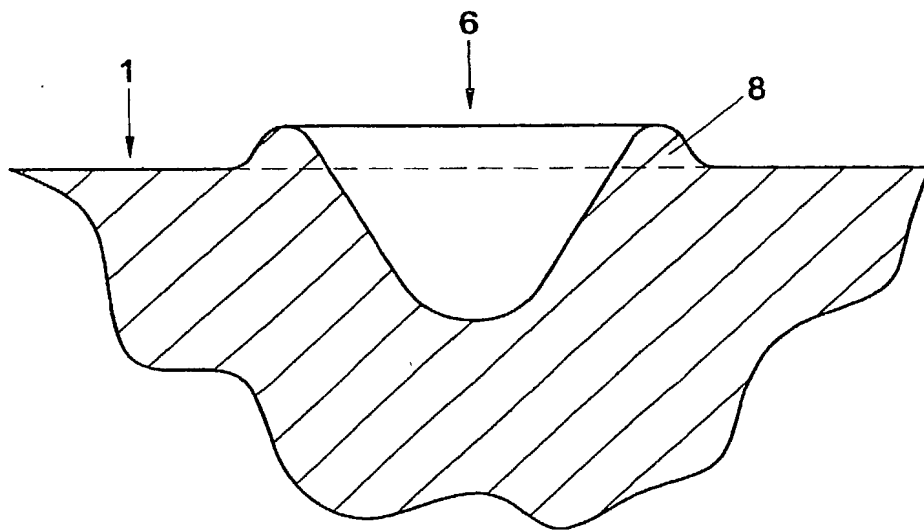


Fig. 4

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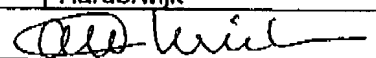
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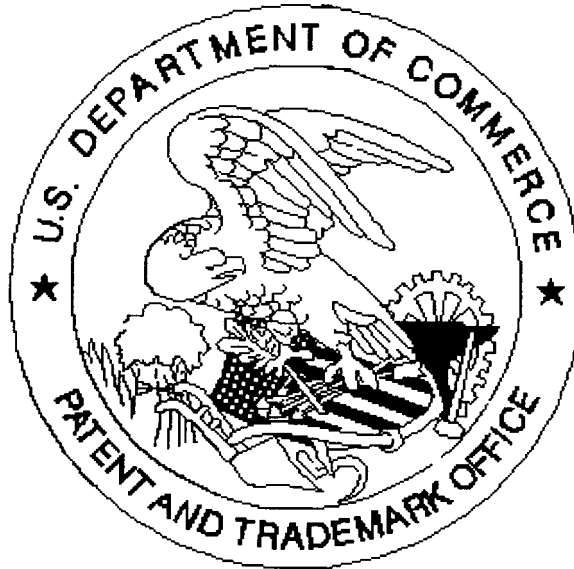
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